



Dart Aerospace Ltd.
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RBW6505G00231-3T
Job Sheet 191734



Part No: RBW6505G00231-3T

Job Qty: 1 pcs

Part Name: AW139 Tail Rotor Gear Box Seal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 6978*

Note: DWG RBW6505G00231-3T Rev 3 IPP Rev A 18.02.07 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/15/19		0.00	1.00	Small Fab - 1		<i>MLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	4/15/19		0.00	1.00	Small Fab - 1 - B4B		<i>MLL</i>
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 4	1 pcs	4/15/19		0.00	0.00	QC 4 - 26		<i>20 / MAR 14 2019</i>
							QC 4 - 28		
							QC 4 - 42		
							QC 4 - 58		
							QC 4 - 6		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/15/19		0.00	0.00	Packaging 3 - 1 - B4B		<i>DAS 28 9-89</i>
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		



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Container No: S161723



Part: RBW6505G00231-3T

Job No: 191734

Serial No/Batch: S161723

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 03/12/19

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					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	4/15/19	0.00 0.00		QC 21 - FG - 21	DAG
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-45 MAR 18 2019

Part Op 100 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-IM2700-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6505G00231-3T-15 to RBW6505G00231-3T-13 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

110 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-IM2700-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6505G00231-3T-15 to RBW6505G00231-3T-13 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

120 - QC4- 100% Inspect kits for completeness

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
138A APP-IM2700-E	Case	1 Ea (1 ea)	100-Small Fab - 1	5134908
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	5145165
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5021040
106 RBW6500X01611-W142H-3T	Tail Rotor Gear Box Output Oil Seal Removal & Press Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5134691
138A RBW6505G00231-3T-11	Bottom Tool Cushion use in case APP-IM2700-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5134910
138A RBW6505G00231-3T-13	Top Tool Cushion use in case APP-IM2700-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5134909
97 RBW6505G00231-3T-15	Inside Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5137847
138 RBW6522A00231-W142AJ-3T	Tail Rotor Gear Box/Servo Actuator Oil Seal Fit/Extracting Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5140705
92 RBW6522A00231-W142AK-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5061472
92 RBW6522A00231-W142S-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5001202

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-IM2700-E	1	4	0
110-Small Fab - 2 - B4B	97524A032	4	406	0
	RB41011	1	393	0
	RBW6500X01611-W142H-3T	1	2	0
	RBW6505G00231-3T-11	1	2	0
	RBW6505G00231-3T-13	1	2	0
	RBW6505G00231-3T-15	1	4	0
	RBW6522A00231-W142AJ-3T	1	2	0
	RBW6522A00231-W142AK-3T	1	2	0
	RBW6522A00231-W142S-3T	1	2	0

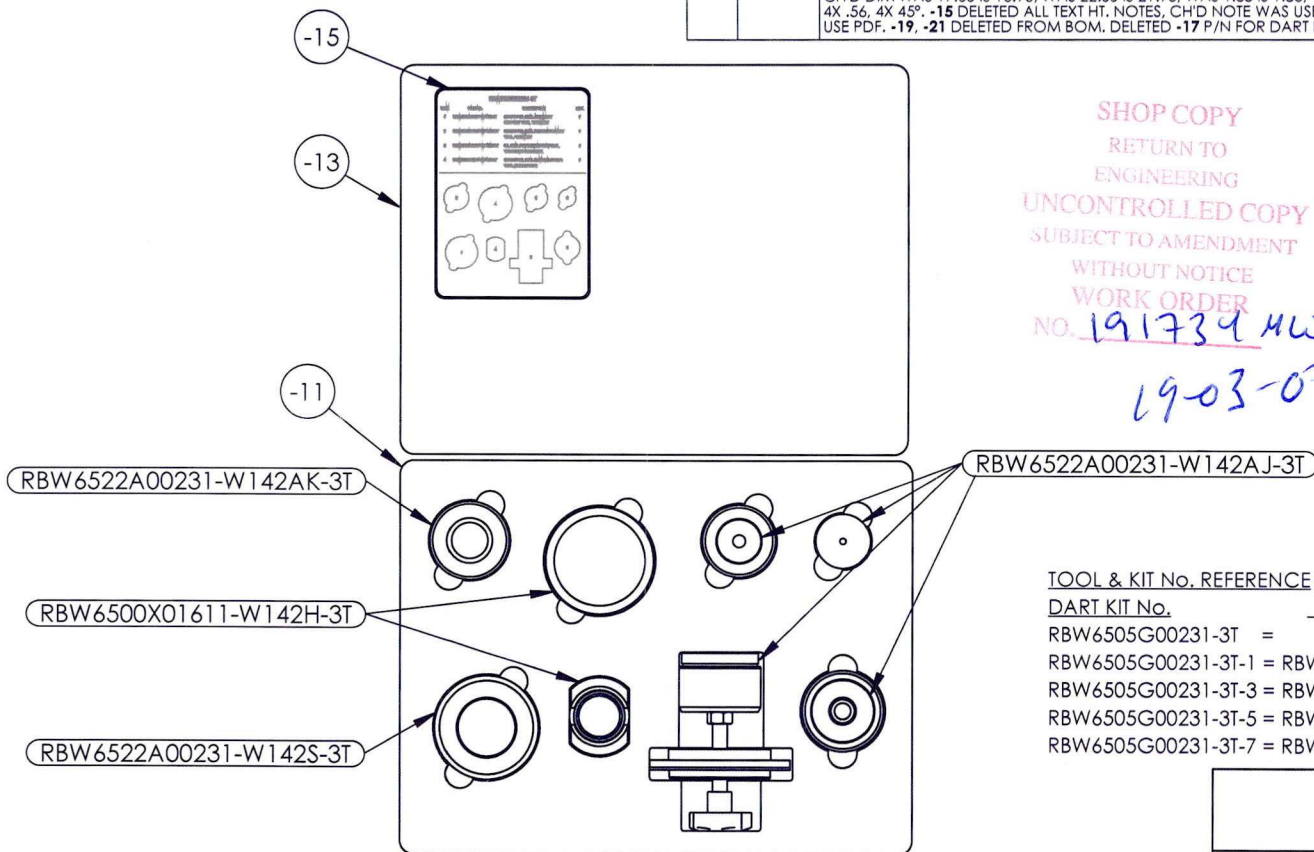
Part Specifications

Specifications could not be found.

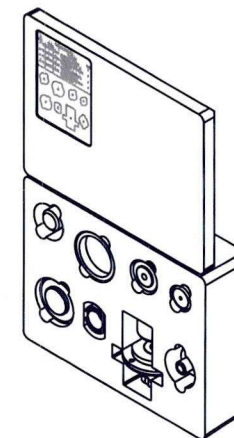
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-11 CH'D DEPTH WAS 3-1/2 IS 4-3/4, WAS 4-3/4 IS 5-9/16. -13 CH'D PLACARD LOCATION CUTOUT WAS HITTING TOOL WITH LID CLOSED.	10/2/2012	RJC	SE
2	15-0145	-11 ADDED MISSING DIM 8X R.13. -13 CH'D DIM WAS .07 IS .13. -15 REPLCED CONTENTS LIST WITH RBW6505G00231-3T, DELETED LINES FROM TOOL LAYOUT, ADDED ITEM NUMBERS TO TOOL LAYOUT. ADDED -19 AND -21.	6/23/2015	RJC	JAG
3	16-0254	-11, -13, -15 CH'D DWG. TO SHEET METAL TOLERANCE. -11, -13 CH'D MATERIAL AND VENDOR WAS Y20 BLACK I.R. SPECIALTY FOAM IS ETHAFOAM 220, BLACK (CASE SOLUTIONS). -11 CH'D DIM WAS 17.00 IS 17.15, WAS 22.00 IS 22.15, WAS 6.00 IS 6.08, WAS 4X 4° IS 4X 2°, ADDED DIM 4X .65, 4X 45°. -13 CH'D DIM WAS 17.00 IS 16.96, WAS 22.00 IS 21.95, WAS 1.88 IS 1.83, WAS 4X 4° IS 4X 2°, ADDED DIM 4X .56, 4X 45°. -15 DELETED ALL TEXT HT, NOTES, CH'D NOTE WAS USE PDF FOR MANUFACTURING IS USE PDF. -19, -21 DELETED FROM BOM, DELETED -17 P/N FOR DART PLACARD.	12/5/2016	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191734 MW
19-03-07



TOOL & KIT No. REFERENCE

DART KIT No.	DART TOOL No.	ORIGINAL No.
RBW6505G00231-3T	=	3T6505G00231
RBW6505G00231-3T-1	= RBW6522G00231-W142S-3T	= 3T6522G00231-W142S
RBW6505G00231-3T-3	= RBW6522G00231-W142AK-3T	= 3T6522G00231-W142AK
RBW6505G00231-3T-5	= RBW6522G00231-W142AJ-3T	= 3T6522G00231-W142AJ
RBW6505G00231-3T-7	= RBW6500X01611-W142H-3T	= 3T6500X01611-W142H

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	TGB/MAST OUTPUT OIL SEAL ASSEMBLY SUPPORT TOOL		RBW6522A00231-W142S-3T	1
				1	OUTPUT OIL SEAL PRESS TOOL		RBW6522A00231-W142AK-3T	1
				1	TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL		RBW6522A00231-W142AJ-3T	1
				1	TGB OUTPUT OIL SEAL REMOVAL AND PRESS TOOL		RBW6500X01611-W142H-3T	1
		B/O	-9	1	CASE	BLACK PLASTIC	PELICAN #APP-IM2700-E	N/S
		B/O	-11	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	6.08 X 17.15 X 22.15 (CASE SOLUTIONS)	2
		B/O	-13	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.83 X 16.96 X 21.95 (CASE SOLUTIONS)	3
			-15	1	INSIDE PLACARD	PLASTIC		4
		B/O		1	DART PLACARD	ALUMINUM	#RB41011	N/S

DART AEROSPACE	
TITLE TGB SEAL REPLACEMENT TOOL KIT	
DWG NO. RBW6505G00231-3T	REV 3
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:8	DATE 1/3/2009
SHEET 1 OF 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					